

Date: Tuesday, 7/10/2007 1:05:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 33457
 Estimate Number : 12784
 P.O. Number : N/A
 This Issue : 7/10/2007 S.O. No. : N/A
 Prsht Rev. : NC Part Number : D35649
 First Issue : N/A Type : SMALL /MED FAB Drawing Number : D3564 REV C
 Previous Run : N/A Project Number : N/A
 Material : N/A
 Due Date : 7/17/2007 Qty: 30 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 07-03-08 ec
 Est Rev: B As per Rev C 07-07-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.9177 sf(s)/Unit Total: 27.5310 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick

Batch: M104725 IB 07-07-16 M103961

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary IB 07-07-16

(30) + 1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary MF 07-07-17
 Form on Brake as per Dwg D3564 using Jigs DT and DT SAD 07/07/17

Form Joggle as per Dwg D3564 on brake using Jig DT SAD 07/07/17

(31) counted

(31)

(31)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33457

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Er 07/07/17 (x31) Cantas

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M105258

m105258

88 07/07/28 8x
FC 07/07/27 21

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/30 (8)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/30 (8)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M1104864

M.L 07/08/03

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 07/08/07 (8)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P18

M.L

07/08/07

13.0

QC21

FINAL INSPECTION/W/O RELEASE



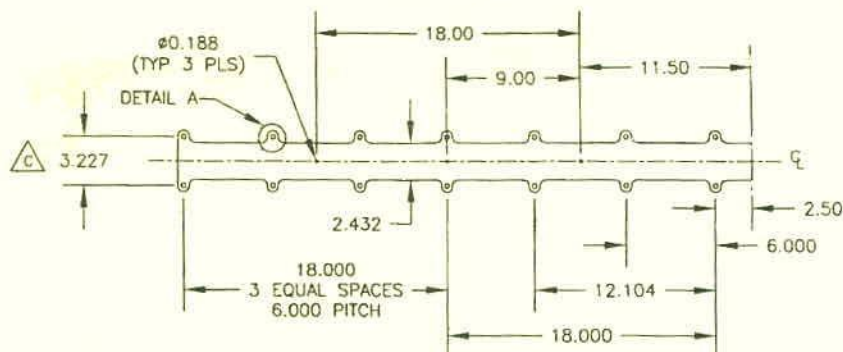
Comment: FINAL INSPECTION/W/O RELEASE

07/08/08 (8)

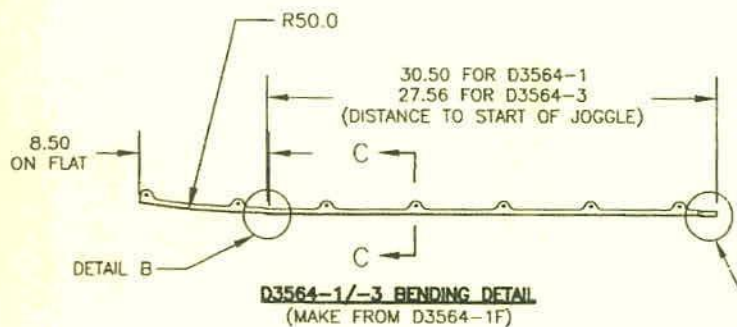
Job Completion



07-08-07

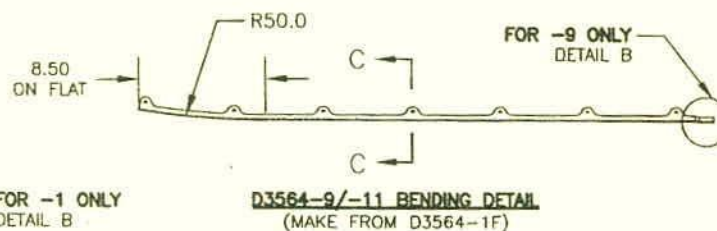


D3564-1F FLAT PATTERN



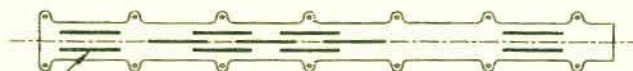
D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -1 ONLY
DETAIL B



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07 06-28-17

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

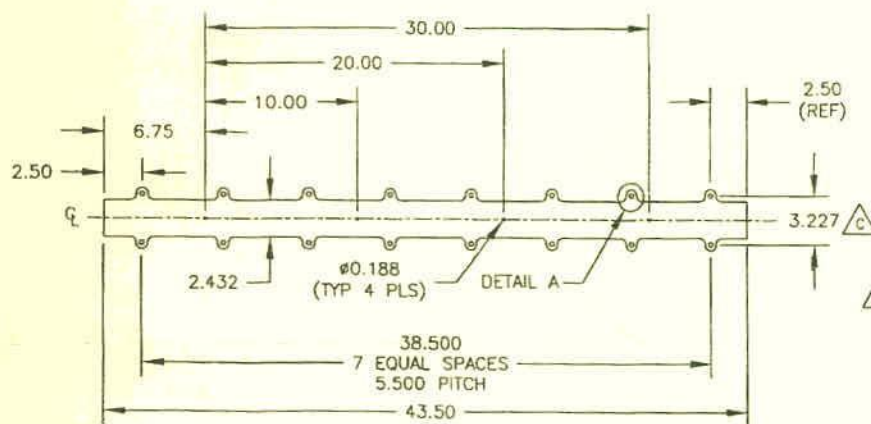
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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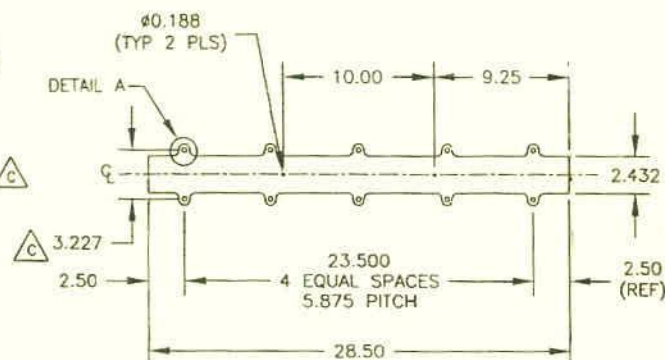
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE		TITLE WEARSHOE
07.04.17		SCALE 1:8

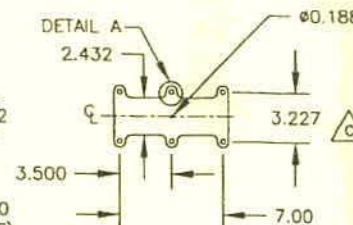
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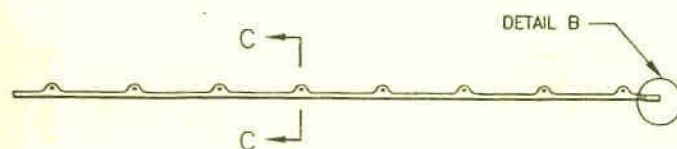
D3564-5F FLAT PATTERN



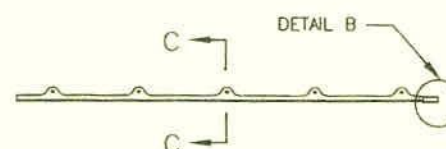
D3564-7F FLAT PATTERN



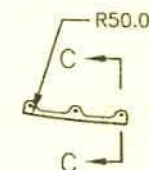
D3564-13F FLAT PATTERN



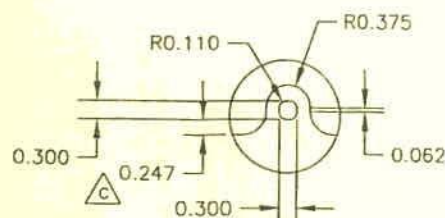
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



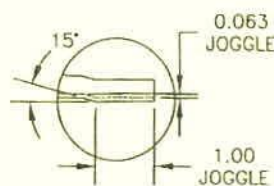
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.06.28-17

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DATE		07.04.17		DRAWING NO.	REV. C
				D3564	SHEET 2 OF 2
				TITLE	SCALE
				WEARSHOE	1:8

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype[illegible]

Measured by: HB	Audited by: En	Prototype Approval:
Date: 07-07-16	Date: 07/07/17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

